

Work Order ID 106539

106539

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September-05-13 3:22:59 PM

Item ID: D3570-2 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket
Start Date: 9/05/13 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 9/12/13 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 DAS 27 9-89 B 9.11				6			
130 *130* Small Fab Small Fab	Small Fab Memo 1-Form as per Dwg D3570 Using DT8945 2-Cut excess material as per Dwg D3570. 3-Drill as per Dwg D3570 Using Dt8946	0.00 0.00				6	6		FF 13-09-24
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 Sh/D B 9.24				6			

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September-05-13 3:22:59 PM

Item ID: D3570-2 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
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 Start Date: 9/05/13 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 9/12/13 Req'd Qty: 6.00 *6* Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				6		7613.925	
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 4:00								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

6x2m/13/04/26

6x4 m/13/04/26

m125028

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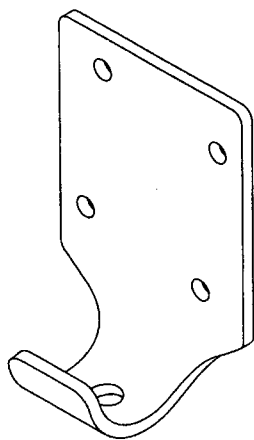
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 Revision ID: Stop *NS2*
 Item Name: Bracket
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 Required Date: 9/12/13 Req'd Qty: 6.00 *6* Customer:
 Reference:

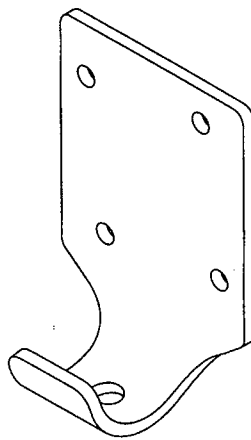
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00				6x			13/09/27
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							13/09/30
Quality Control									

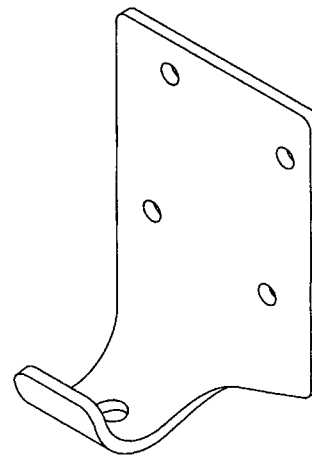
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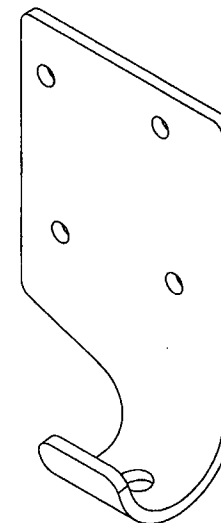
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

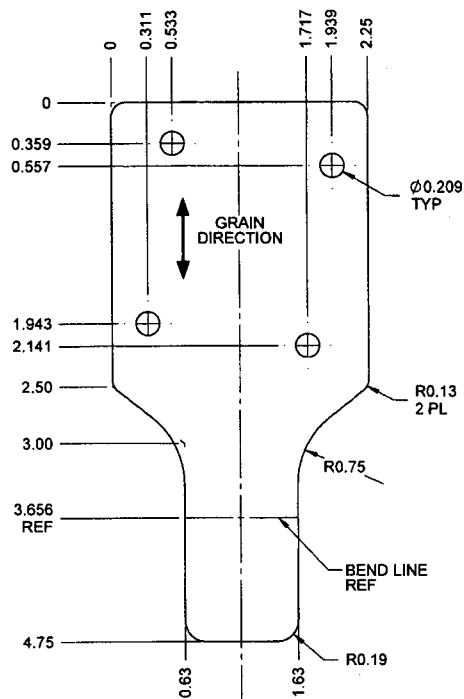
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09/04/22

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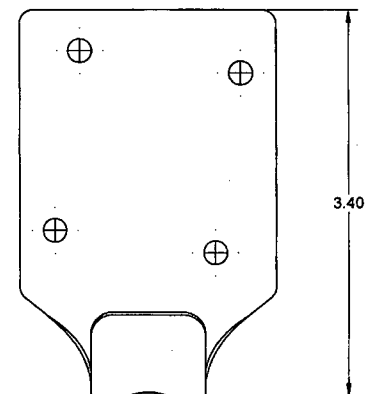
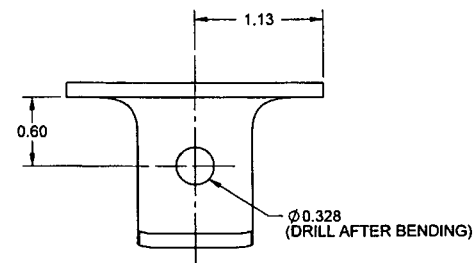
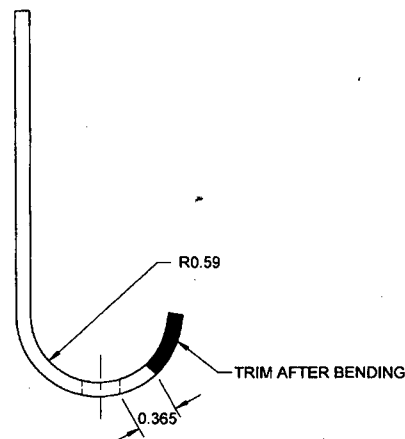
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M8061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN. SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/81. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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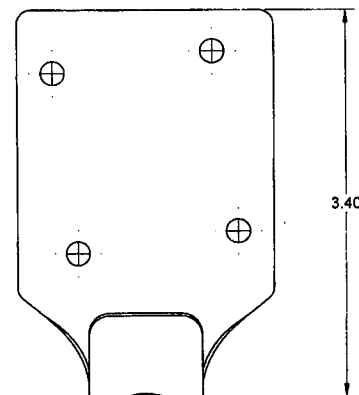
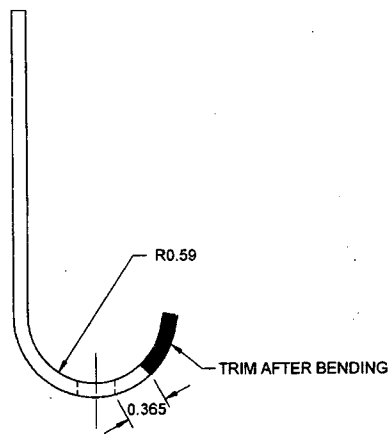
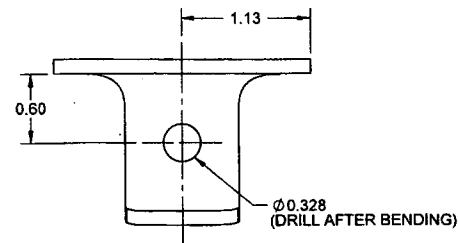
D3570-1F FLAT PATTERN



D3570-1 BRACKET
(MAKE FOM D3570-1F)

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24/04/13

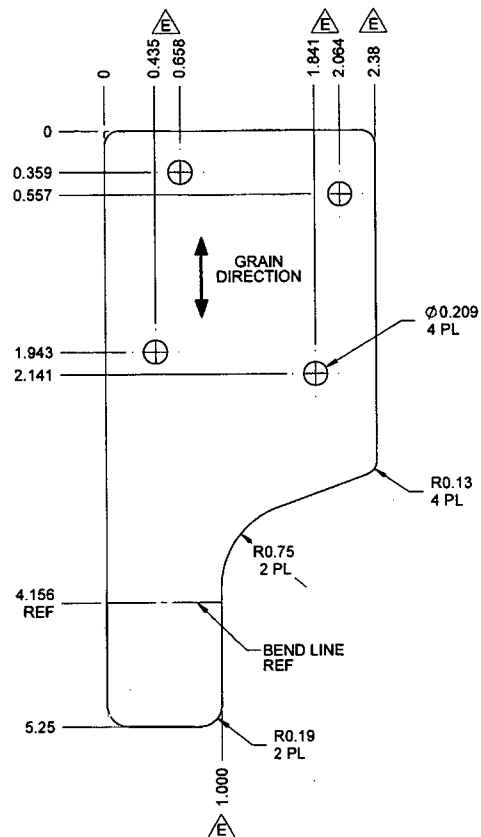
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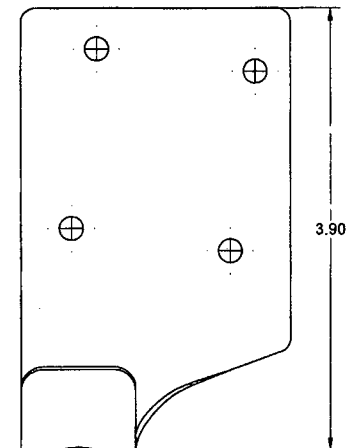
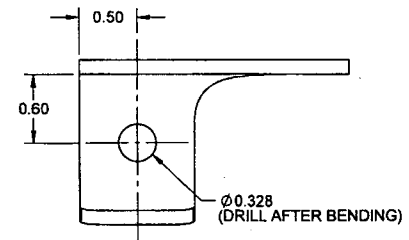
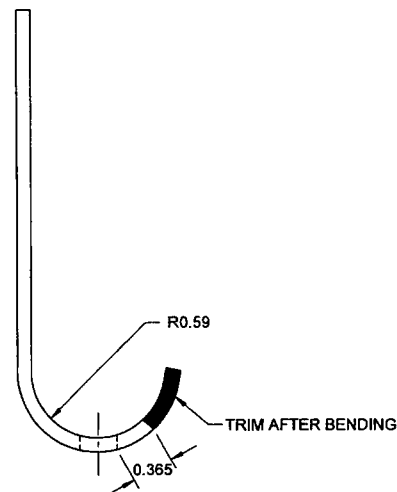
D3570-2 BRACKET
(MAKE FROM D3570-1F)

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09/04/22

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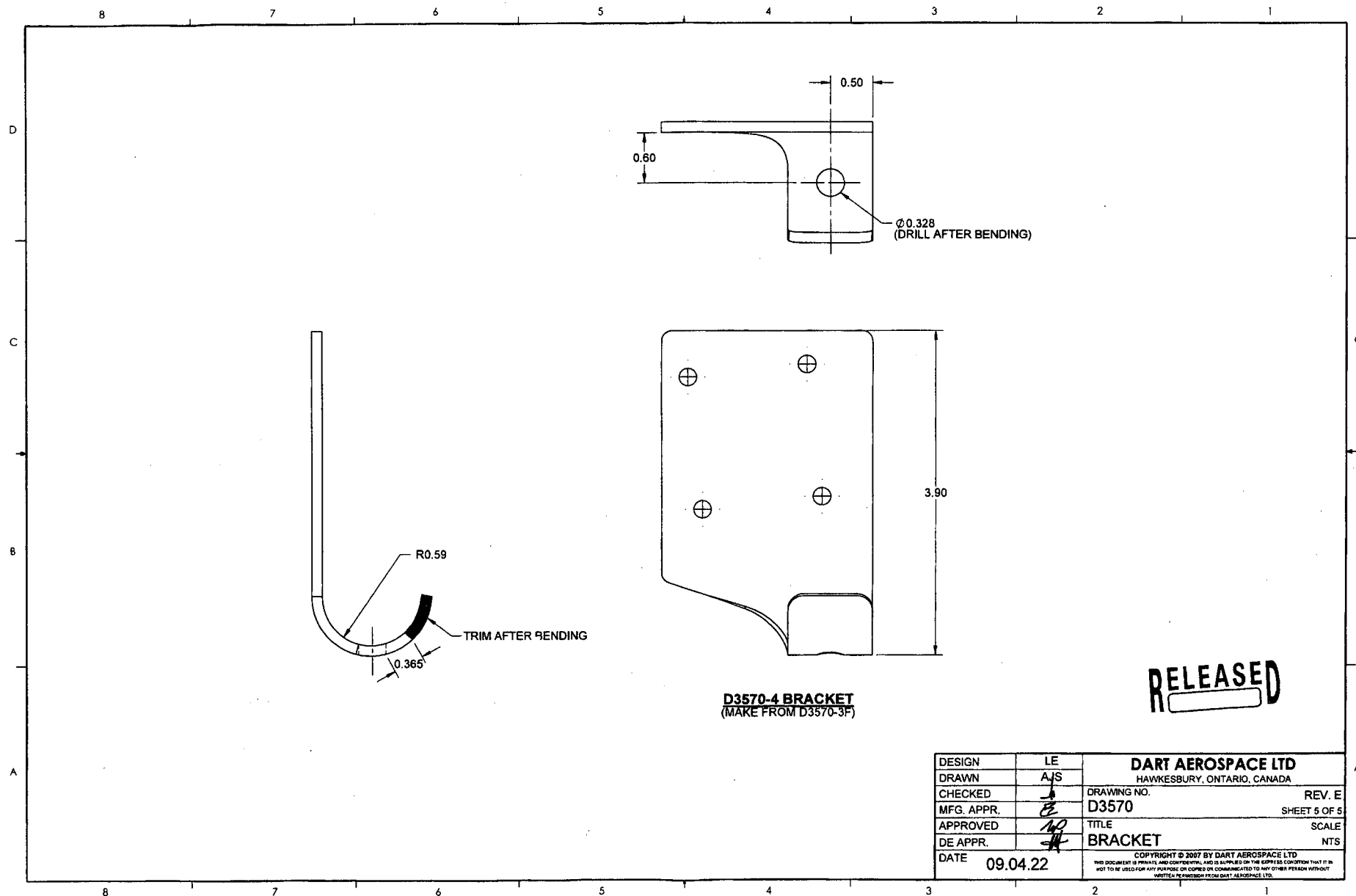
D3570-3F FLAT PATTERN



D3570-3 BRACKET
(MAKE FROM D3570-3F)

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07/24/22 MD

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D3570-4 BRACKET
(MAKE FROM D3570-3P)

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MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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